

# Work Order ID 62769

October 7, 2010 3:37:52 PM



Page 1

Item ID: D2196-1

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 10/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/10/08 Tooling:

Date:

Run Start



QC: Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2196	Rev C								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2196 ☐ Dwg Rev: C ☐ Prog Rev: C ☐ 2-  
Deburr if necessary

304 .063

FB 10-10-7

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

FB 10-10-7

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

5 10/10/08

(43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62769

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Cust Item ID:

Required Date: 10/14/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Brake NC

NC BRAKE

0.00

Memo

0.00

Bend as per dwg D2196

Brake NC

SA 10/07/10

2

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

3

10/07/10

150



Packaging

Identify as per dwg & Stock Location: 8

0.00

Memo

0.00

Packaging

10/07/10 SA SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62769**

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Setup Start



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Item Name: Bracket

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Cust Item ID:

Required Date: 10/14/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/20 [Signature]

ME

10-10-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

October 8, 2010 8:03:46 AM

Page 1

Work Order ID: 62769

Parent Item: D2196-1

Parent Item Name: Bracket



Start Date: 10/07/10

Required Date: 10/14/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

sf

63.8100

0.211

0.211

.7



BK-10-7

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT

57.97

111323

0

115688

57.97

MAT20

5.84

115440

5.84

115688

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	62769
<b>Description:</b> Bracket		<b>Part Number:</b>	D2196-1
<b>Inspection Dwg:</b> D2196 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.130	X		V HB 02	
Ø0.203	+0.005/-0.001	.205	X		V	
Ø0.316	+0.006/-0.001	.317	X		V	
0.375	+/-0.010	.374	X		V	
0.813	+/-0.010	.812	X		V	
1.750	+/-0.010	1.748	X		V	
2.688	+/-0.010	2.688	X		V	
3.625	+/-0.010	3.624	X		V	
4.000	+/-0.010	4.002	X		V	
0.375	+/-0.010	.375	X		V	
1.200	+/-0.010	1.200	X		V	
2.390	+/-0.010	2.389	X		V	
3.960	+/-0.010	3.958	X		V	
5.530	+/-0.010	5.535	X		V	
6.730	+/-0.010	6.730	X		V	
7.230	+/-0.010	7.226	X		V	

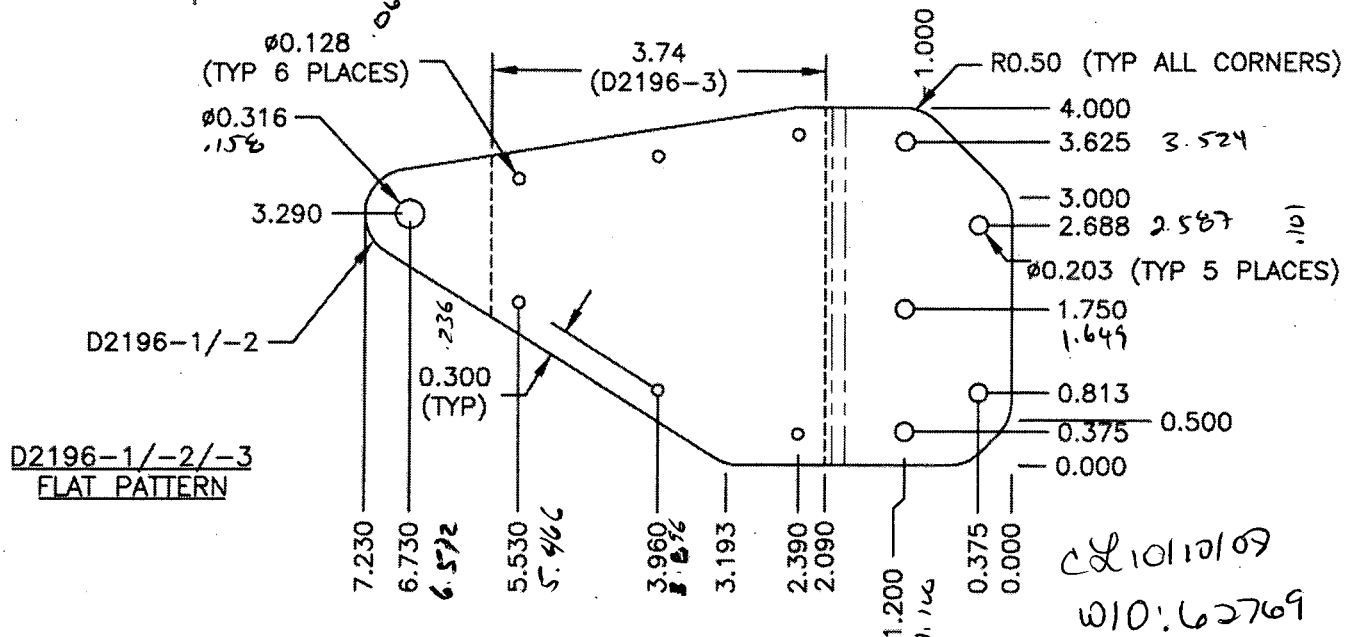
<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-12-7	<b>Date:</b> 10/10/08	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.08.27	New Issue	KJ/DD	



**DART**

DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2196	REV. C SHEET 1 OF 1
DATE	03.05.28			TITLE BRACKET	SCALE 1:2
B	93.09.23			REDESIGN	
C	03.05.28			REDRAW; D2196-3 NOW 0.5" THICK	

**RELEASED**  
03.07.09**D2196-1/-2**

- 1) MATERIAL: AISI 304/316 S.S.  
0.064" THICK (M304S16GA)

**D2196-3**

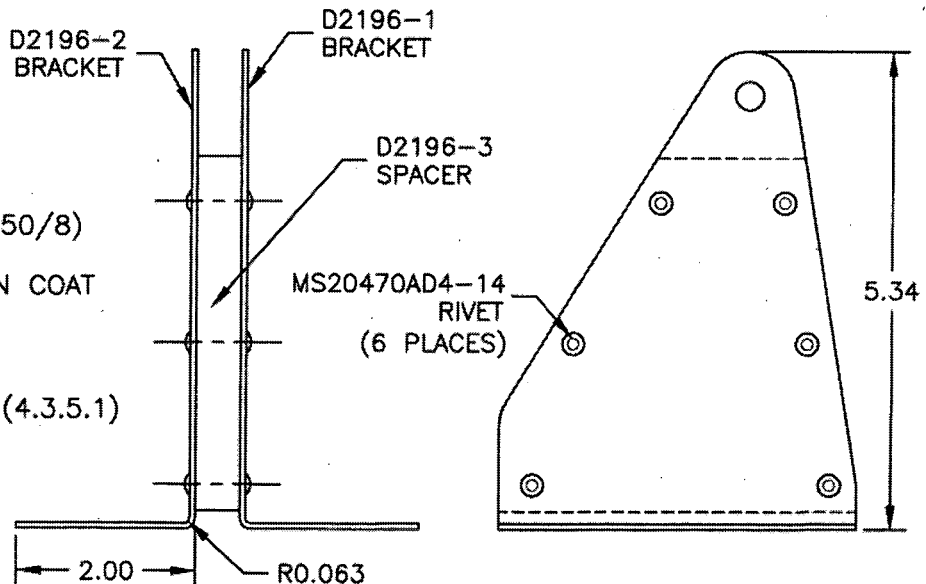
- 2) MATERIAL: 5052H32 (QQ-A-250/8)  
0.500" THICK 4x0.125 THICK  
3) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1

**D2196 BRACKET (ASSEMBLY):**

- 4) FINISH: POWDER COAT WHITE (4.3.5.1)  
PER DART QSI 005 4.3

**GENERAL NOTES:**

- 5) ALL DIMENSIONS ARE IN INCHES  
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
7) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D2196 BRACKET  
(ASSEMBLY)**

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